Work Order ID October-30-13 7:32:1			*1089	947*							Page 1
Item ID: D227 Revision ID: Item Name: Step L			Accept	*N900	040	100	ገ*	Setup	Start Stop	*N: *N:	S1*
Start Date: 10/30 Required Date: 11/25 Reference:		*20* *20*		Cust Item I Customer:	D:		,				
Approvals: Proc	ess Plan: MC5	Date: 13-10-30	Tooling:	Da	ıte:	_		Run	Start	1/1	R1*
				Da	ıte:				Stop	*N	R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D2278	Rev F										
100	FLOW WATER JET		0.00				26/	^			Jm3-11-11
Waterjet	Memo		0.00				-507				<u>JA15 11-11</u>
GOULO SO	1-Cut as pe Deburr if n	or Dwg D2278 Dwg Rev:_ eccessary	Prog Rev: /	_ 2-							
110	QC2- Inspect parts off n	nachine FAI/FAIB	0.00								
110 QC; Quality Control	Memo		0.00				34	<u>0</u>			JmB-11-11
*120	QC8- Inspect parts - sec	cond check	0.00				QY				
QC Quality Control	Memo		0.00 27	l b			and				

DQA:			Date:										TOAR
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT		ork Order up	odate only	AEROSPACE,
-						DISPOSITION			۸۵		PARTMENT		:
Work Orde	er:					DIST 05111014	. 1			AIN31 DE	PANTIVIENT <i>)</i>	- PROCE33	
						Rework			Skid-tube Cros	sstube		Water Jet	Engineering
Part N	No					Scrap		!	Machining Sma	all Fab	Pro	d. Eng. Coor.	Quality
						Use-as-is		Thern		nishing	Rec/Stor	re/Packaging	Other
NCR N	No. —					Suspected Unapproved			Large Fab Com	posite		Supplier	
Root					Desc	ription of work order update		nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process		ı	-										
Supplier					*								
Training													
Transport													
Unapproved													
							FAI	JLT CAT	TEGORY				
Landi	ng Ge	ar				General						1 1	
	Ве	ending			`	Bend		Folio/P	rogram		Outside Dime	ensions [Pressure/Forced
:	Ce	entre No	t Concer	ntric		BOM/Route		Grain			Over/Under	 	Set-up
	Cr	acks				Broken/Damage/Defect		Hardwa	re		Part Incorred	⊢	Temperature/Cure
	Cr	imp/Kin	k/Ripple	/Wave		Burrs		Inspecti	ion Incomplete/Unqualifie	ed	Part Lost/Mi)	Weld
	Cı	uffs				Contamination		1	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	Cr	ushing				Countersink			ned/off center		Positioned W	L. ∕rong	
	Н	eat Trea	t			Cut Too Short		Mislabe			Power Loss/S		Other
	In	spection	Strip in	Tube		Drawing		Misread		L	1	U	1
	_	arks/Ch				Drill Holes	-	Off-set					
	Πtι	irning Se	equence			Finish			Calibration				
	\square_{w}	ave/Twi	ist in Tub	e		Fit/Function		ı	Sequence				

Work Orde		8947		*108	3947*							Page 2	
Item ID: Revision ID: Item Name:	D2278 Step Leg			Accept	*N900	040	100	ገ*	Setup	Start Stop	ı u,	S1* S2*	
Start Date: Required Date: Reference:	10/30/13 11/25/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:							
Approvals:	•	an:	Date:	Tooling: SPC (Y/N):		ate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center II 130 *120* HandFinish Hand Finishing	D	Operation Description Chemical Conversion Co Memo	at per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accep Qty	Qty	y	Reject Number	Insp. Stamp	
140 *140* QC: Quality Control		QCA Inspect Part Finish Memo		0.00			ć	24	<u>,</u>			13/11/	/zc
150		Identify as per dwg & Sto	ock Location.	0.00								/	

0.00

Memo

150 Packaging

Packaging

DQA:			Date:										TAART
QA Closed:			Date:			WORK ORDER NON	-CC	ONFOI	RMANCE / U		Vork Order up	odate only	AEROSPACE
Work Orde	or.					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
WON ONG	-''-					Rework	1		Skid-tube	Crosstube	٦	Water Jet	Engineering
Part N	lo.					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					_	Use-as-is	1		noforming	Finishing		re/Packaging	Other
NCR N	No. <u> </u>					Suspected Unapproved]		Large Fab	Composite		Supplier	
Root		·			Desci	ription of work order update	Π	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
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Offset/Setup													
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	В	ending				Bend		Folio/F	Program	L	Outside Dim	ensions	Pressure/Forced
	L C	entre No	t Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	tolerance	Set-up
	Cr	racks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	ct	Temperature/Cure
	cr	rimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing	Weld
	Cı	uffs				Contamination		Instruct	tions Incomplete/l	Jnclear	Part Moved		Wrong Stock Pulled
	Щc	rushing				Countersink		Misalig	ned/off center		Positioned V	Vrong	_
	Щн₁	eat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
	ln	spection	Strip in	Tube		Drawing		Misread	d				
	Шм	larks/Ch	atter			Drill Holes		Off-set					
	∐Tı	urning Se	equence			Finish		Out of 0	Calibration				
	Ιlw	/ave/Tw	ist in Tub	e e		Fit/Function		Out of	Sequence				

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Work Ord				*108	3947*						Page	3
Item ID: Revision ID: Item Name:	D2278 Step Leg			Accept	*N900	<u>040</u>	100)*	Setup Sta	1.71	S1* S2*	
Start Date: Required Date: Reference:	10/30/13 : 11/25/13	• •	*20* *20*		Cust Item I Customer:	ID:						
Approvals:	Process	Plan:	Date:	Tooling:	D:	ate:		1	Run Sta	1/1	R1*	ı
	QC:		Date:	SPC (Y/N):	D:	ate:			Sto	*N	R2*	
Sequence ID/ Work Center II 160 *160* QC	D	Operation Description QC21- Final Inspection Memo	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Quality Control											13-1	1-20

DQA:		_ Date:			. WORK ORDER NON	~	281501	DAAAACE / LIDDATE				1	TRAGG [*]
QA Closed:		Date:			WORK ORDER NON-	-((JNFO	RIVIANCE / UPDATE	W	ork Order uj	odate only		AEROSPACE
Mark Orda			-		DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
Work Orde	er:				Rework	1				1	18/-A (-AF	_	
Part N	do.				Scrap			Skid-tube Crosstube Machining Small Fab	_	Dro	Water Jet	-	Engineering
, aren					Use-as-is			noforming Finishing	_	-1	d. Eng. Coor. re/Packaging	\dashv	Quality Other
NCR N	No.				Suspected Unapproved		Inch	Large Fab Composite	-	1 1160/3101	Supplier	-	Other
	 					·		zar8e raz sempesite		J	oupplie.[
Root				Desci	ription of work order update		nitial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	ı	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup													
Process													
Supplier													
Training													
Transport					·								
Unapproved		<u> </u>	L			<u> </u>							
						FA	ULT CA	TEGORY			- 4.		
Landir	ng Gear				General		le 1: . 75	.		1	. г	-	-
	Bending	ot Concer	a+=i.a	-	Bend BOM/Route	\vdash	1	Program	-	Outside Dim	ļ		ressure/Forced
	Cracks	or concer	TUTIC	\vdash	Broken/Damage/Defect	<u> </u>	Grain		\vdash	Over/Under	 -	_	et-up
		nk/Ripple	Mayo	-	1 ' " '	<u> </u>	Hardwa		\vdash	Part Incorre	<u> </u>		emperature/Cure
	Cuffs	iik) kippie	y wave	\vdash	Burrs Contamination	\vdash	1	ion Incomplete/Unqualified	\vdash	Part Lost/Mi	issing	┥.	Veld
	Crushing			\vdash	Countersink	\vdash	4	cions Incomplete/Unclear gned/off center	-	Part Moved	L	 ۱^	Vrong Stock Pulled
	Heat Tre			-	Cut Too Short	\vdash	Mislabe		-	Positioned V Power Loss/		\neg_{\sim})than
	_	ac on Strip in	Tube		Drawing	-	Misrea			Trower ross/	ourge [ther
	Marks/C		·unc	\vdash	Drill Holes	-	Off-set						
ł	—	Sequence			Finish	 -	1	Calibration					
ŀ		vist in Tul		-	Fit/Function		1	Seguence					

Picklist Print

October-30-13 7:32:22 AM

Work Order ID: 108947

108947

D2278 Parent Item:

D2278

Parent Item Name: Step Leg

Start Date: 10/30/13

Required Date: 11/25/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A IPP Rev:B

New Issue 05-11-07 Now 6061-T6 06-06-23

JLM JLM

IPP Rev C

New flat pattern 08.01.11 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	492.5680	0.9815	21-			
M6061T6	SS 080								**	ລລ			Jm13-11

6061-T6 .080 Sheet

Location	Loc Qt	Loc Code	
MAT021	492.5	68	
125	812 32.	75	
m12	26309 352	2.5	12630
m12	26350 107.3	18	·

DQA:		Date:			_								•	na int
					WORK ORDER NON	-C(ONFO	RMANCE / I	UPDATE					AFROSPACE
QA Closed:		Date:						·		W	ork Order u	odate only]
					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Work Order:					, ,	7		a			1		_	1 —
David No.					Rework	ł		Skid-tube	Crosstube	-		Water Jet		Engineering
Part No	·				Scrap	-		Machining	Small Fab		1	d. Eng. Coor.		Quality
NCR No					Use-as-is Suspected Unapproved	-	inern	noforming	Finishing		Rec/Sto	re/Packaging	\vdash	Other
INCK INC	·	 	<u>:</u>		Suspected Onapproved			Large Fab	Composite	L	J	Supplier	_	
Root	1			Desc	ription of work order update		Initial	Α	ction		Sign &			1
Cause	Date	Step	Qty		or non-conformance	1	nief Eng		scription		Date	Verificatio	n	QC Inspector
Design		1												
Doc/Data	7													
Equip/Tooling	7					l								
Handling/Pre	7					1								
Material														
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport					·									
Unapproved														
						FΑ	ULT CAT	regory						
Landing	Gear				General		_				_		_	_
<u> </u>	Bending			L	Bend	L	Folio/F	Program		L	Outside Dim	ensions	L	Pressure/Forced
<u> </u>	Centre N	ot Concer	ntric		BOM/Route	L	Grain				Over/Under	tolerance	L	Set-up
	Cracks			<u> </u>	Broken/Damage/Defect	L	Hardwa	ire			Part Incorre	ct		Temperature/Cure
_		nk/Ripple	/Wave	_	Burrs	<u> </u>	Inspect	ion Incomplete/	Unqualified		Part Lost/Mi	issing		Weld
· L	Cuffs			_	Contamination		Instruct	tions Incomplete	e/Unclear		Part Moved			Wrong Stock Pulled
-	Crushing				Countersink		Misalig	ned/off center	r	L	Positioned V	Vrong		
	Heat Trea				Cut Too Short	L	Mislabe	eled		L	Power Loss/	Surge		Other
	Inspectio		Tube	<u> </u>	Drawing		Misread	t						
	Marks/Cl			<u> </u>	Drill Holes		Off-set							
		Sequence			Finish		Out of 0	Calibration						
	Wave/Tw	vist in Tub	e e	1	Fit/Function	1	Out of	Sequence						

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DART AEROSPACE LTD	Work Order:	108947
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

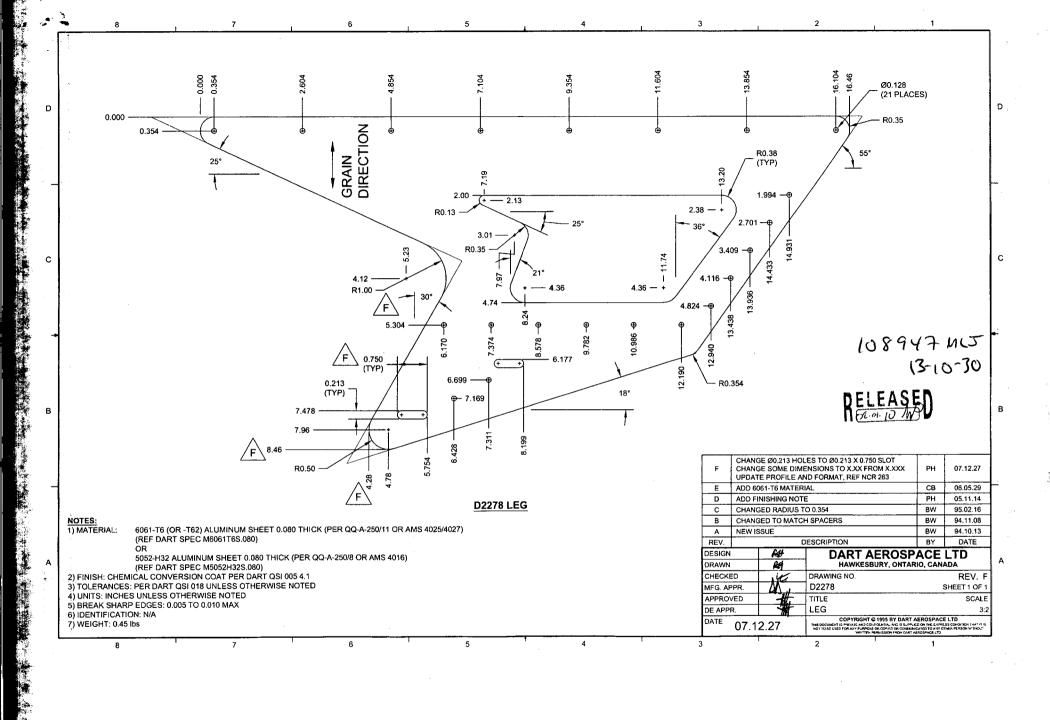
X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.354	+/-0.010	0.356"	_		U	Ikmoi
0.354	+/-0.010	0.358"	_		V	
16.46	+/-0.030	16.46"			T	Jim 06
Ø0.128	+0.005/-0.000	0.138"	_		ν	
R0.354	+/-0.030	0.354	_		RG	
2.00	+/-0.030	2.008"	-	,	ν	
4.74	+/-0.030	4.74	_		V	
8.46	+/-0.030	8,476"	_		V	Producor
0.213	+/-0.010	0.215	_		V	
0.750	+/-0.010	0.754	_		V	
0.080 thick	+/-0.010	0.080"	_		~	
						
•						
			DAS			

| Measured by: | Jr. | Audited by: | 9-89 | Prototype Approval: | N/A |
| Date: | (3-//-// | Date: | S //-// | Date: | N/A |

Rev	Date	Change	Revised by	Approved
Α	04.10.12	New Issue P/O D2582	KJ/JLM	
В	06.03.08	Dwg Rev. changed	KJ/JLM	
С	06.06.23	Dwg Rev. changed	KJ/JLM .	
D	08.02.28	Dimensions updated per Dwg Rev F	KJ/DD 🔏	N
			, ()	V -

DQA:			Date:												
QA Closed: Date:					WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only									AEROSPACE	
Q. Closed.												EPARTMENT/PROCESS			
Work Orde	er: _					DISPOSITION	POSITION AGAINS			AGAINSI	DE	PAKTIVIENT	PROCESS		
						Rework		Skid-tube Crosstube				Water Jet			Engineering
Part N	اo					Scrap]]		Machining	Small Fab		Prod. Eng. Coor.			Quality
						Use-as-is	<u> </u>	Thermoforming Finishing				Rec/Store/Packaging			Other
NCR N	No					Suspected Unapproved		Large Fab Composite			<u> </u>	Supplier			
Root		-			Descr	ription of work order update	 	I Initial	Actio	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description			Date Verification		n	QC Inspector
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	Bending					Bend		4	Program		_	Outside Dim	ensions	L	Pressure/Forced
	Centre Not Concentric					BOM/Route	<u> </u>	Grain			<u> </u>	Over/Under	tolerance	L	Set-up
	Cracks					Broken/Damage/Defect		Hardware			<u> </u>	Part Incorrect		<u></u>	Temperature/Cure
	Crimp/Kink/Ripple/Wave					Burrs	<u> </u>	Inspection Incomplete/Unqualified			<u> </u>	Part Lost/Missing		Weld	
-	Cuffs					Contamination	<u></u>	Instructions Incomplete/Unclear			<u> </u>				Wrong Stock Pulled
	Crushing					Countersink	<u></u>	1 .	gned/off center		Positioned		•	_	1
	Heat Treat					Cut Too Short	<u></u>	Mislabe	·		Ц.	Power Loss/	Surge		Other
ļ	Inspection Strip in Tube					Drawing	<u></u>	Misread							
	Marks/Chatter					Drill Holes		Off-set							
ļ	Turning Sequence					Finish	<u></u>	Out of Calibration							
Wave/Twist in Tube						Fit/Function	1	IOut of 9	Sequence						



DQA:			Date:		<u></u>	-								
QA Closed:			Date:			WORK ORDER NON-	AEROSPACE							
						DISPOSITION	ON AGAINST DEPARTMENT/PROCESS							
Work Orde	er: _				_	200001			and the C	с	7	\A(a+a= a+		
Part N	lo		·····			Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Water Jet Prod. Eng. Coor.		Engineering Quality	
NCR N	۱o					Use-as-is Suspected Unapproved		Thermoforming Finish Large Fab Compos			Rec/Stol	re/Packaging Supplier -	Other	
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Cause		Date	Step	Qty		or non-conformance	l I		ription	Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved								5						
	. 1		!	<u> </u>			FAI	ULT CA	TEGORY					
Landi	ng G	ear				General								
		Bending Centre No	ot Concer	ntric		Bend BOM/Route Broken/Damage/Defect		Folio/Program Grain			Outside Dimensions Over/Under tolerance		Pressure/Forced Set-up	
	Cracks Crimp/Kink/Ripple/Wave						\vdash	Hardware			Part Incorrect		Temperature/Cure	
	Cuffs Cuffs					Burrs Contamination	\vdash	Inspection Incomplete/Unqualified Instructions Incomplete/Unclear			Part Lost/Missing Part Moved		Weld	
:	Crushing					Countersink	\vdash				Positioned V	L. Vrong	Wrong Stock Pulled	
	Heat Treat					Cut Too Short	\vdash	Misaligned/off center Mislabeled			Power Loss/	_	Other	
	Inspection Strip in Tube					Drawing	<u> </u>	1		L	rower Loss/	Juige	Tottlet	
	Marks/Chatter					Drill Holes	\vdash	Misread Off-set						
	Turning Sequence					Finish	\vdash	4	Calibration					
	Wave/Twist in Tube					Fit/Function	-	4	Sequence					
						programedon	1	TOUL OF:	JEGUENCE					